

Date: Monday, 12/01/2009 3:22:43 PM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MOUNTING LUG
 Job Number : 44700
 Estimate Number : 10255
 P.O. Number :
 This Issue : 12/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D22301
 Drawing Number : D2230 REV F
 Project Number : N/A
 First Issue : / / Type : MACHINED PARTS Drawing Revision : F
 Previous Run : 43444 Material :
 Due Date : 21/01/2009 Qty: 200 Um: Each
 Written By :
 Checked & Approved By : *CL09/01/12*
 Comment : Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total: 14.3430 f(s)
 Lug Extrusion D2423 Extrusion
 Batch: *43722*

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut D2423 extrusion to 0.82"
 Batch: _____

cut @ meter

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine per folio D2230-1 *machine as per design*
 (Check for crack while loading into the machine.) *D2230REV.F*
 2-Tumble and deburr rough edges after tumbling

CL09/01/13

200

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Rec'd + inspect for surface damage.
CofC attached

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC5 SECOND CHECK



Comment: SECOND CHECK

S02/01/29 +202
inspect level 5

CL09/01/28 (202)
CL09/01/28 (202)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 09/02/02

200

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-02-03

200

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME:

10:25

OVEN TEMPERATURE:

320°

FINISH TIME:

10:55

FL / MD 09/02/03

200

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 09-02-03

200

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST476

SS 09/02/05

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/05

Job Completion



u 09.02.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

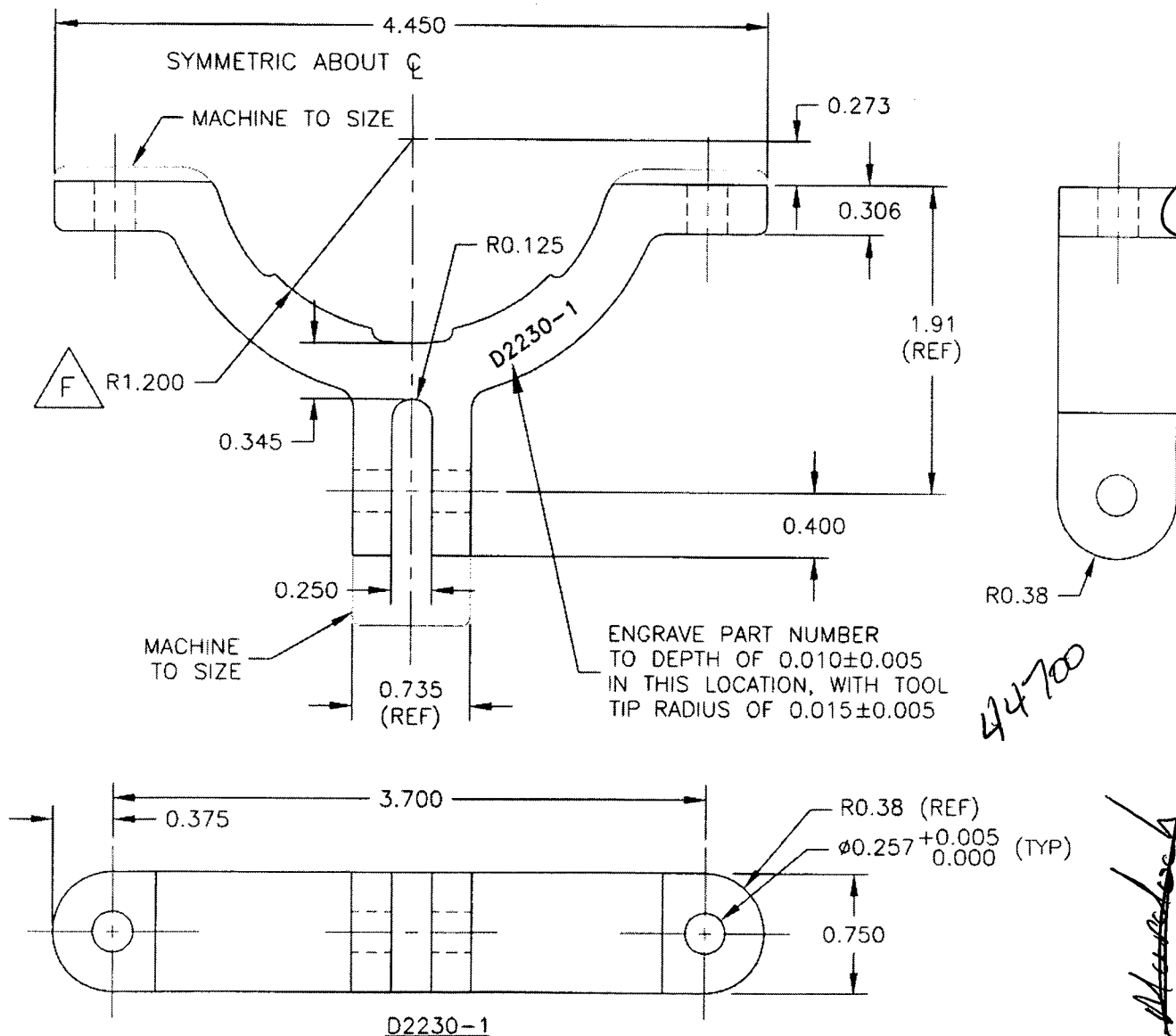
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D2230	REV. F SHEET 1 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1
C	94.03.30	RE-DESIGN	
D	95.01.04	RE-DESIGN	
E	95.01.04	RE-DESIGN	
F	99.12.13	REDESIGN; R1.200 WAS R1.100	

RELEASED
9.12.21 DS

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>Q JANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
202	D2230-1 MATERIAL: supplied by DART	Mounting Lug D2423 B43722	7950
100	D2230-3 MATERIAL: supplied by DART	Mounting Lug D2423 B43722	7950

S. Orland

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Denise Robinson

Vankleek Hill, January 28, 2009